

Date: Friday, 11/18/2005 3:18:02 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 24838	
Estimate Number : 10531	
P.O. Number : N/A	Part Number : D2572
This Issue : 11/18/2005 S.O. No. : N/A	Drawing Number : D2572 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 244331	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 12/20/2005 Qty: 12 Um: Each
Checked & Approved By : SEE COMMENT BELOW	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: 25204

M8 06/01/21

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 24838 Double check by: JG 06/01/21

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets M8 06/01/22
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets M8 06/01/22
4-Deburr and remove all machining marks M8 06/01/22
5-Tumble to remove shap edges. N/A

12

J.G 06/01/24

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

J.G / M8 06/01/22

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:18:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 24838

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.6/M8 06/01/22

12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EG 06.01.28

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MA 06 01 30

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MA 06 01 30

12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C2006/01/31

12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 372

C2006/01/31

12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/01

(12)

Q 06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024838	Department Code:	
Project Name	: D2572	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2572	Invoice Number	:
Description	: Saddle, Fwd, In	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	:	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD	Work Order: 24838
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.757		
C	3.495	3.505		3.500	3.500	3.500	3.498		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.002	8.003	8.001	8.003		
F	0.490	0.510		.503	.501	0.502	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.500	.498	.503	0.506		
J	1.174	1.184		1.180	1.180	1.181	1.180		
K	0.558	0.578		.571	.570	.576	0.569		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.497	1.495	1.494	1.497		
N	2.495	2.505		2.500	2.500	2.500	2.501		
O	3.869	3.879		3.874	3.873	3.874	3.870		
P	0.115	0.135		.127	.127	.127	0.128		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.250	.250	0.250		
S	0.115	0.135		.129	.124	.132	0.135		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.964	2.962	2.961	2.964		
V	0.230	0.250		.247	.243	.251	0.249		
W	0.115	0.135		.129	.125	.130	0.125		
X	0.307	0.312		.309	.309	0.311	0.312		
Y	0.760	0.765		.762	.762	0.761	0.761		
Z	0.352	0.372		.366	.366	.362	0.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631	.628	.627	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.253	.256	0.255		
AE	1.375	1.395		1.386	1.386	1.380	1.379		
AF	0.115	0.135		.135	.135	.135	0.134		
AG	0.240	0.280		.252	.255	.255	0.250		
AH	0.240	0.260		.257	.257	.258	0.260		
AI	2.000	2.020		2.004	N/A	N/A	N/A		
AJ	0.023	0.043		.03	.03	.03	.03		
Accept/Reject									

Measured by:	M8 / J.G.
Date:	06/01/22

Audited by:	✓
Date:	06/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
15-20

DART AEROSPACE LTD	Work Order:	24838
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.502	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.002	8.002	8.000		
F	0.490	0.510		0.501	0.500	.501	.499		
G	0.257	0.262	DT8683	0.258	0.258	✓	✓		
H	0.375	0.380	DT8684	0.376	0.376	✓	✓		
I	0.490	0.510		0.494	0.500	.503	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		0.569	0.568	.572	.575		
L	1.174	1.184		1.180	1.179	1.180	1.180		
M	1.490	1.500		1.495	1.497	1.496	1.495		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.874	3.873	3.873		
P	0.115	0.135		0.128	0.127	.127	.127		
Q	0.115	0.135		0.134	0.134	.135	.135		
R	0.240	0.260		0.253	0.253	.250	.250		
S	0.115	0.135		0.132	0.133	.130	.130		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.962		
V	0.230	0.250		0.249	0.252	.245	.246		
W	0.115	0.135		0.130	0.131	.131	.131		
X	0.307	0.312		0.311	0.310	.310	.310		
Y	0.760	0.765		0.761	0.761	.762	.762		
Z	0.352	0.372		0.362	0.362	.365	.365		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		0.628	0.627	.629	.629		
AC	0.053	0.073		0.063	0.063	.063	.063		
AD	0.240	0.260		0.251	0.252	.254	.252		
AE	1.375	1.395		1.378	1.379	1.380	1.380		
AF	0.115	0.135		0.130	0.135	.135	.135		
AG	0.240	0.280		0.251	0.252	.250	.250		
AH	0.240	0.260		0.255	0.256	.256	.256		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	.030	.030		
Accept/Reject									

Measured by: J.G. / M8
Date: 06/01/25

Audited by:
Date: 06/01/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
15-20

DART AEROSPACE LTD	Work Order:	24838
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.503	.502	.500	.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.502	.505	.502	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.572	.571	.572	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.493	1.495	1.493	1.492		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.872	3.872		
P	0.115	0.135		.127	.127	.128	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.250	.250		
S	0.115	0.135		.129	.127	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.961	2.965	2.965		
V	0.230	0.250		.244	.243	.244	.244		
W	0.115	0.135		.128	.128	.126	.126		
X	0.307	0.312		.310	.310	.310			
Y	0.760	0.765		.762	.762	.762			
Z	0.352	0.372		.364	.362	.365	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.254	.251	.253	.250		
AE	1.375	1.395		1.380	1.380	1.380	1.382		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.258	.258		
AH	0.240	0.260		.254	.256	.256	.256		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	MS
Date:	06/01/26

Audited by:	JG
Date:	06/01/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
15-20

